

Date: Wednesday, 3/19/2008 3:20:02 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : NUT PLATE ASSEMBLY  
 Job Number : 37941  
 Estimate Number : 11053  
 P.O. Number :  
 This Issue : 3/19/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2873043  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2873 REVA  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 4/2/2008 Qty: 20 ~ Um: Each  
 Written By :  
 Checked & Approved By : HA 08 03 19  
 Comment : Est A 05.09.13 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

Estimate Number:

M6061T6B0375X01000

6061T6 BAR

Q. Number:



This Issue:

Comment: Qty: 0.3237 f(s)/Unit Total : 6.4743 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-3

Batch: M107220

(20)

H.A 08/03/25

20

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 3.700" long

30

HAAS1

HAAS CNC VERTICAL MACHINING #1



(20)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-3

Dwg Rev A Folio Rev AA

DIP/H.A

08/03/25

40

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP/H.A

08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/19/2008 3:20:02 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 37941

Part Number: D2873043

Job Number:



Seq. #

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/03/26 (20)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

X 20

ml 08/03/26

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/26 (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-26 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

FL 08/03/26 (20)

10.0

MS20426AD46

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total: 120.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

M105144 ✓

ml

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

M 18136 ✓

ml 08/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/19/2008 3:20:02 PM

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 37941

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

ml 08/03/07 X 20

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/07 (X20)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 08-03-27 (X20)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



mf 0.8-03-27

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37941
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-3
<b>Inspection Dwg:</b> D2873 <b>Rev:</b> A		<b>Page 1 of 1</b>	

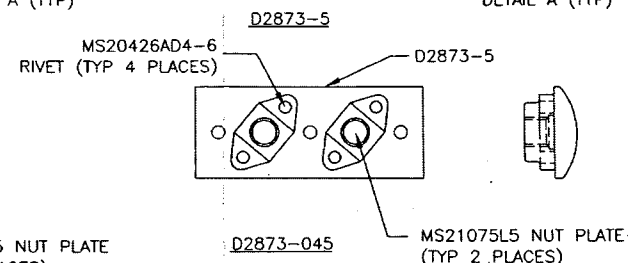
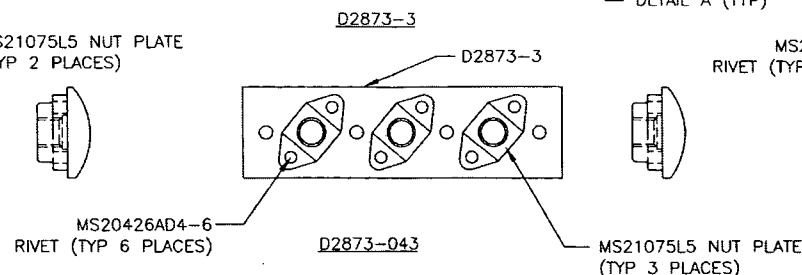
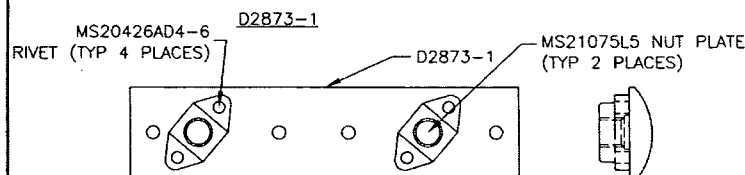
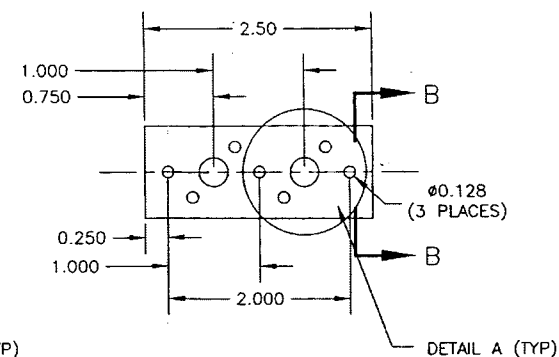
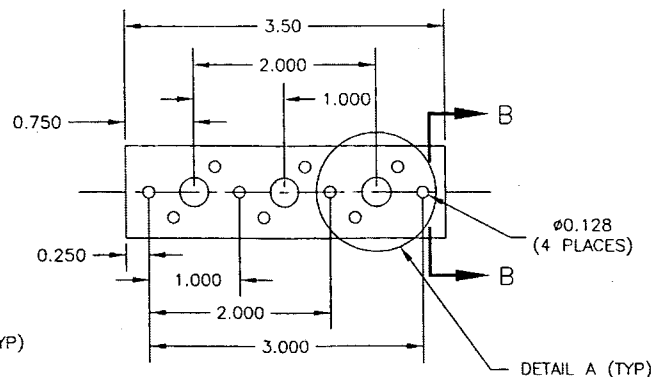
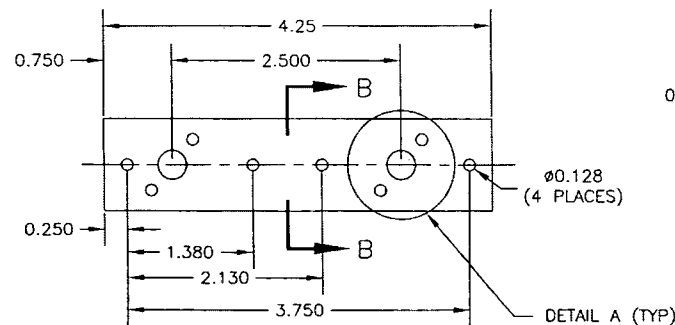
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500				
2.000	+/-0.010	1.999				
0.750	+/-0.010	0.749				
1.000	+/-0.010	0.999				
0.250	+/-0.010	0.251				
1.000	+/-0.010	1.001				
2.000	+/-0.010	2.000				
3.000	+/-0.010	3.000				
Ø0.128	+0.005/-0.001	Ø0.129				
0.359	+/-0.010	0.3595				
Ø0.316	+0.006/-0.001	Ø0.318				
1.000	+/-0.010	0.9955				
0.250	+/-0.010	0.251				
0.061	+/-0.010	0.062				
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.229				

<b>Measured by:</b> H.A. / [Signature]	<b>Audited by:</b> DJP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/03/25	<b>Date:</b> 08/03/26	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue      P/O D2873-043	KJ/JLM [Signature]	[Signature]



D2873-041

D2873-043

D2873-045

**D2873-1/-3/-5 RADIUS BLOCK**

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

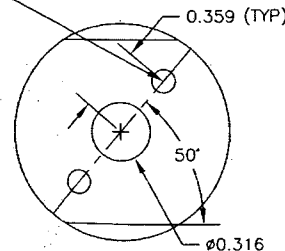
**D2873-041/-043/-045 NUT PLATE ASSEMBLY**

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

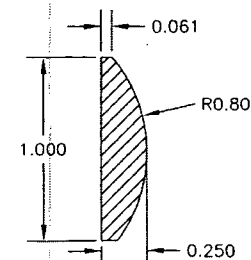
**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

(-041 4 PLACES)  
(-043 6 PLACES)  
(-045 4 PLACES)



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED  
05-07-26

NO. 37041  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5